

Date: Friday, 08/08/2008 11:24:18 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: PRELIM.		
Job Number	: 41077					
Estimate Number	: 10804					
P.O. Number	:		Part Number	: D412777011		
This Issue	: 08/08/2008	S.O. No. :	Drawing Number	: D412-777-011		
Prsht Rev.	: NC		Project Number	:		
First Issue	: / /	Type : MACHINED PARTS	Drawing Revision	:		
Previous Run	: 00015		Material	:		
Written By	:		Due Date	: 15/08/2008	Qty:	1
Checked & Approved By	:				Um:	Each
Comment	:					

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1 
		<i>Soc(s) 88</i> Comment: PACKAGING RESOURCE #1 PICK PACKING KIT: 
2.0	D2182B	Rubber Cushion  <i>Paper work D412-777-04 CNG001</i> Comment: Qty.: 12.0000 f(s)/Unit Total : 12.0000 f(s) Rubber Cushion 26 X D2182B055 (5.5") <i>48 B34777 18 B39986 SQ</i>
3.0	D2274	Radius Block  <i>91 20 B32857 32 B39238 SY</i> Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s) Radius Block
4.0	D2521	Bearpaw 205  <i>35062 50 8/8/8 ④</i> Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bearpaw 205
5.0	D2529	Washer  <i>B32025 ⑤ 8/8/8 50</i> Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Washer

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Seq. #: Machine Or Operation:

Description :

6.0 D2947 Clamp

8
⑧



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
Clamp

B30386

B36826

SP

7.0 D37951 Ski Fwd

⑨



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Ski Fwd

B40674

SP

8.0 D37953 Ski Mid

B40623



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Ski Mid

8/8/8

SP

9.0 D3796041 FWD WEARPLATE WELDMENT

B41111



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
FWD WEARPLATE WELDMENT

8/8/19

SP

10.0 D3796043 AFT WEARPLATE WELDMENT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
AFT WEARPLATE WELDMENT

B41110

8/8/4 SP

11.0 AN412A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bolt

M105143

SP

12.0 AN417A Bolt



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)
Bolt

M10F321

SP

13.0 AN9704 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

8/8/8

SP

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Seq. #: Machine Or Operation:

Description :

14.0 AN960JD416

Washer



M108161

(18)

Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Washer



20

15.0 MS2104L4

Nut



M105054

(25)



32

(14)

Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

M105054 (8)

8/8/8

M107478

50

16.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



ENGINEERING
APPROVAL



Comment: INSPECT 100% KITS FOR COMPLETENESS

408,08,20

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP

41077

408,08,20

(40)

18.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.08.20

POSITIVE RECALL

EFFECTIVE 08.08.08

AUTH U

RELEASED

DATE 08.09.08

08.09.08

ENGINEERING
DEPARTMENT

3.1.4 Position the D3695-1 FWD Ski Section and D3796-041 Wearplate as shown in Figure 1.

3.1.3 The D2521 Bearpaw, D3795-1 Forward Ski Section and D3795-3 Mid Ski Section may be relieved to clear the wearshoe mounting screws provided the relief leaves 0.375in thickness.

3.1.4 Attach the D2947 Clamps, D2182B055 Rubber Cushion and associated hardware in the holes as shown in Figure 3 and Section A-A.
CAUTION: The torque on the nuts should be limited to 20 in-lb.

3.1.5 Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4 bolts with longer or shorter AN4 bolts, if required.

3.1.6 Lower the aircraft

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-777-011	72.0 lb 32.7 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	115 in 2.93 m	8280 in-lb 95.8 m-kg

5.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D412-777-011	BEARPAW INSTALLATION
26	D2182B055	RUBBER CUSHION
52	D2274	RADIUS BLOCK
2	D2521	BEARPAW
12	D2529	WASHER
26	D2947	CLAMP
2	D3795-1	FWD SKI SECTION
2	D3795-3	MID SKI SECTION
2	D3796-041	FWD WEARPLATE
2	D3796-043	AFT WEARPLATE
8	AN4-12A	BOLT
52	AN4-17A	BOLT
8	AN970-4	WASHER
52	AN960JD416	WASHER
60	MS21042L4	NUT (OR MS21042-4)

Preliminary Issue
10.08.20

3.1.3 The D2521 Bearpaw, D3795-1 Fwd Ski Section and D3795-3 Mid Ski Section may be relieved to clear the wearshoe mounting screws provided the relief leaves 0.375in thickness.

3.1.4 Attach the D2947 Clamps, D2182B055 Rubber Cushion and associated hardware in the holes as shown in Figure 1 and Detail A, B and C.
CAUTION: The torque on the nuts should be limited to 20 in-lb.

3.1.5 Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4 bolts with longer or shorter AN4 bolts, if required.

3.1.6 Lower the aircraft

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-777-011 Ski Installation	72.0 lb 32.7 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	123.7 in 3.14 m	8906 in-lb 102.7 m-kg

5.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D412-777-011	SKI INSTALLATION
26	D2182B055	RUBBER CUSHION
52	D2274	RADIUS BLOCK
2	D2521	BEARPAW
12	D2529	WASHER
26	D2947	CLAMP
2	D3795-1	FWD SKI SECTION
2	D3795-3	MID SKI SECTION
2	D3796-041	FWD WEARPLATE
2	D3796-043	AFT WEARPLATE
8	AN4-12A	BOLT
52	AN4-12A 074	BOLT
8	AN970-4	WASHER
52	AN960JD416	WASHER
60	MS21042L4	NUT (OR MS21042-4)